

Work Order ID 68352

Tuesday, April 12, 2011 10:09:25 AM



Page 1

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 4/12/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: Date: 11-04-12Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3791	Rev A								
100		0.00							
	-FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3791								
304 . 063	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-4-18

(12)

B11-4-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	4/15/2011	Req'd Qty: 12.00		Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130 Brake NC Brake NC	NC BRAKE Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3791 using Jigs	0.00 0.00							
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D3429	0.00 0.00							

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Large Fab

Large Fab

0.00

Memo

0.00

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: *m117238*

EL 11-5-3 (X12)

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Set up ulostor

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Set up ulostor

(412)

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Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M 115128</i> Memo START TIME: <i>11:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>12:10</i>	0.00 0.00				<i>12</i>	<i>BL</i>	<i>11-5-3</i>	
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>12</i>	<i>4</i>	<i>11-5-3</i>	
200 Packaging Packaging	Identify as per dwg & Stock Location <i>FP-17</i> Memo	0.00 0.00				<i>12</i>	<i>BL</i>	<i>11-5-3</i>	

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Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/49
11-053
(12)

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:09:32 AM

Page 1

Work Order ID: 68352



Parent Item: D3791-1



Parent Item Name: Wearplate



Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	241.0000	0.2917	3.684632			
304/316 Sheet .063												1811-4-18	
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT020			241						
				117275			241			117275			

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Dart Aerospace Ltd

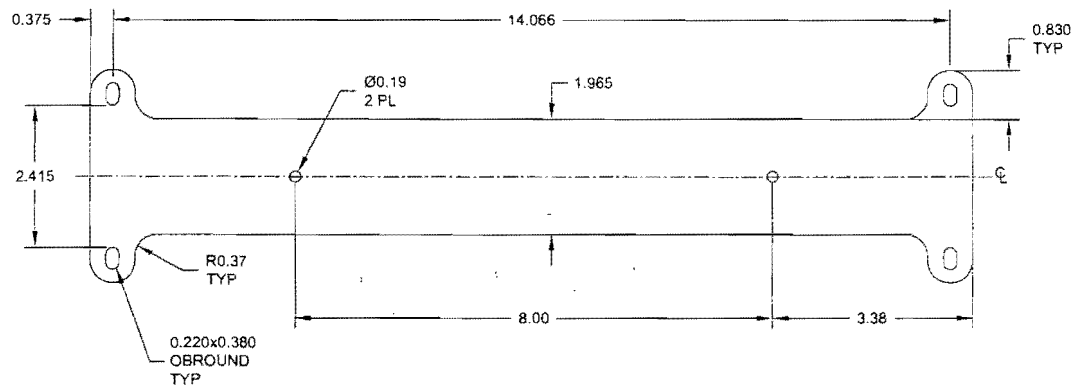
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

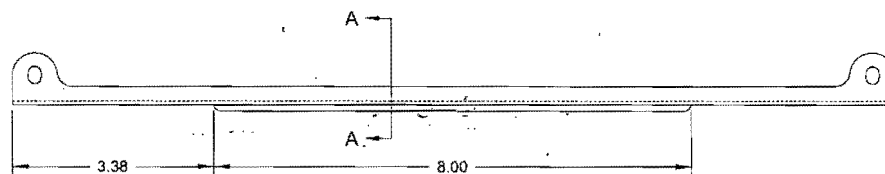
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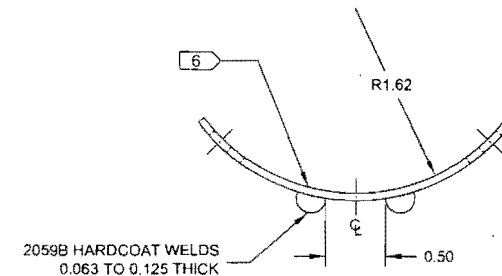
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 48352

PH 11-04-12

RELEASED
08-05-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A NEW ISSUE		PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	<i>PH</i>		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	<i>PH</i>	WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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